Work Order ID 90230

September-12-12 3:42:47 PM

90230

Item ID: D2571 **Accept** *N900040100* **Setup** **Start** *NS1*
Revision ID:
Item Name: Saddle, Fwd Out 205 **Stop** *NS2*

Start Date: 12/09/2012 **Start Qty:** 8.00 *8* **Cust Item ID:**
Required Date: 02/10/2012 **Req'd Qty:** 8.00 *8* **Customer:**
Reference:

Approvals: **Process Plan:** MLJ **Date:** 12/09/12 **Tooling:** **Date:** **Run** **Start** *NR1*
QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2571	Rev E

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1	0.00	FK 12-10-?			8	ɸ		
	Memo Program Batch No. 9023* Double check by: F.K. 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets3-Machine Step No 3 per Folio FA051 and inspect	0.00	FK 12/10/04						
110 *110* Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE	0.00				8	ɸ		
	Memo Machine keyway as per dwg D2571 & D2572	0.00	F.K 12/10/04						
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB	0.00				8	ɸ		
	Memo	0.00	FK 12/10/04						

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ______	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ______	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ______
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	______	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	______	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	______	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 90230

September-12-12 3:42:47 PM

90230

Item ID:	D2571	**Accept**	*N900040100*
Revision ID:		**Setup Start**	*NS1*
Item Name:	Saddle, Fwd Out 205	**Stop**	*NS2*
Start Date:	12/09/2012	**Start Qty:** 8.00 *8*	**Cust Item ID:**
Required Date:	02/10/2012	**Req'd Qty:** 8.00 *8*	**Customer:**
Reference:			

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	D.G.	12/10/12		8	∅		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				8	[illegible]	12-10-15	
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum **Memo** START TIME: 8-10 OVEN TEMPERATURE: 320°F FINISH TIME: 8-40	0.00 0.00				8X	∅		ML 12/10/16

M122878

DQA: ________ Date: ______________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ______	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
NCR No. ______	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 90230
September-12-12 3:42:47 PM

90230

Item ID: D2571
Revision ID:
Item Name: Saddle, Fwd Out 205

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 12/09/2012 **Start Qty:** 8.00 *8*
Required Date: 02/10/2012 **Req'd Qty:** 8.00 *8*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run **Start** *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish	0.00				8.	∅	12-10-16	[stamp]
	Memo	0.00							
170 *170* Packaging Packaging	Identify as per dwg & Stock Location ST-441	0.00				8x			8D 12-10-16
	Memo	0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00					12/10/17		[initials]
	Memo	0.00							

MF 12-10-16

DQA: ________ Date: ________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: ________ Date: ________

Work Order: ________

Part No. ________

NCR No. ________

DISPOSITION

- [ ] Rework
- [ ] Scrap
- [ ] Use-as-is
- [ ] Work Order Update

AGAINST DEPARTMENT/PROCESS

Skid-tube [ ]	Crosstube [ ]	Water Jet [ ]	Engineering [ ]
Machining [ ]	Small Fab [ ]	Prod. Eng. Coor. [ ]	Quality [ ]
Thermoforming [ ]	Finishing [ ]	Rec/Store/Packaging [ ]	Other [ ]
Large Fab [ ]	Composite [ ]	Supplier [ ]	[ ]

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	[ ]									
Equip/Tooling	[ ]									
Operator	[ ]									
Material	[ ]									
Setup	[ ]									
Other	[ ]									
Process	[ ]									
Supplier	[ ]									
Training	[ ]									
Unapproved	[ ]									

FAULT CATEGORY

Landing Gear

- [ ] Bending
- [ ] Centre Not Concentric to O/S
- [ ] Cracks
- [ ] Crushed/Crimped
- [ ] Cuffs
- [ ] Heat Treat
- [ ] Inspection Strip in Tube
- [ ] Ripples in Bend
- [ ] Torque Waves in Extrusion
- [ ] Turning Sequence
- [ ] Wave/Twist in Tube

General

- [ ] Bend
- [ ] BOM/Route
- [ ] Broken/Damaged
- [ ] Burrs
- [ ] Contamination
- [ ] Countersink
- [ ] Cut Too Short
- [ ] Drill Holes
- [ ] Drawing
- [ ] Finish
- [ ] Folio
- [ ] Grain
- [ ] Hardware
- [ ] Inspection Incomplete
- [ ] Instructions Incomplete/Unclear
- [ ] Maintenance
- [ ] Mislabeled
- [ ] Misread
- [ ] Offset
- [ ] Out of Calibration
- [ ] Out of Sequence
- [ ] Outside Dimensions
- [ ] Ovalized
- [ ] Over/Under tolerance
- [ ] Part Incorrect
- [ ] Part Lost/Missing
- [ ] Part Moved
- [ ] Positioned Wrong
- [ ] Power Loss/Surge
- [ ] Pressure/Forced
- [ ] Temperature/Cure
- [ ] Weld
- [ ] Wrong Stock Pulled
- [ ] Other ________

Picklist Print

September-12-12 3:42:51 PM

Work Order ID: 90230

90230

Parent Item: D2571

D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 12/09/2012 **Required Date:** 02/10/2012

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP: I02.10.02Re-format: Change to Dwg Rev. D & incorporated D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007 *D6101-007* Saddle Billet		Manufactured	No			100	Each	18.0000	1 **	8	Ld	2-10.3	

Location	Loc Qty	Loc Code	
MAT041	52		
85432	1		
88516	16		
MAT042	-34		
85432	1		12

89349

could not pull.

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Part No. ______	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
NCR No. ______	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

DART AEROSPACE LTD	Work Order:	90230
Description: Saddle, Fwd Outboard	**Part Number:**	**D2571**
Inspection Dwg: D2571 Rev. E		**Page 1 of 1**

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.499	.499		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.501	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.124	.124	.124	.124		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.252	.253	.252	.252		
S	0.115	0.135		.130	.130	.129	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.242	.240	.242	.240		
W	0.115	0.135		.120	.121	.120	.120		
X	0.308	0.313		.310	.310	.309	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.365	.363	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.629	.629	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.248	.250		
AE	1.375	1.395		1.389	1.388	1.388	1.389		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.004	2.003	2.004	2.004		
AJ	0.023	0.043		.063	.063	.063	.063		
Accept/Reject				✓	✓	✓	✓		

Measured by:	FK		Audited by	A.A
Date:	12/10/04		Date:	12/10/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[signature]

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order	Disposition	Against Department/Process
Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**
Part No. ____________	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

DART AEROSPACE LTD	Work Order:	90230
Description: Saddle, Fwd Outboard	**Part Number:**	**D2571**
Inspection Dwg: D2571 Rev. E		**Page 1 of 1**

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	5	6	7	8	**By**	**Date**
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.498	.500	.499	.499		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.124	.125	.125	.125		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.253	.253	.253	.253		
S	0.115	0.135		.129	.129	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.120	.120	.119	.120		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.364	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.629	.629	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.249	.249	.249		
AE	1.375	1.395		1.389	1.390	1.389	1.390		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.249	.250	.250	.249		
AI	2.000	2.020		2.004	2.006	2.0045	2.005		
AJ	0.023	0.043		.063	.063	.063	.063		
	Accept/Reject			✓	✓	✓	✓		

Measured by:	F.K.	Audited by	B.A
Date:	12/10/05	Date:	12/10/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[signature]

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

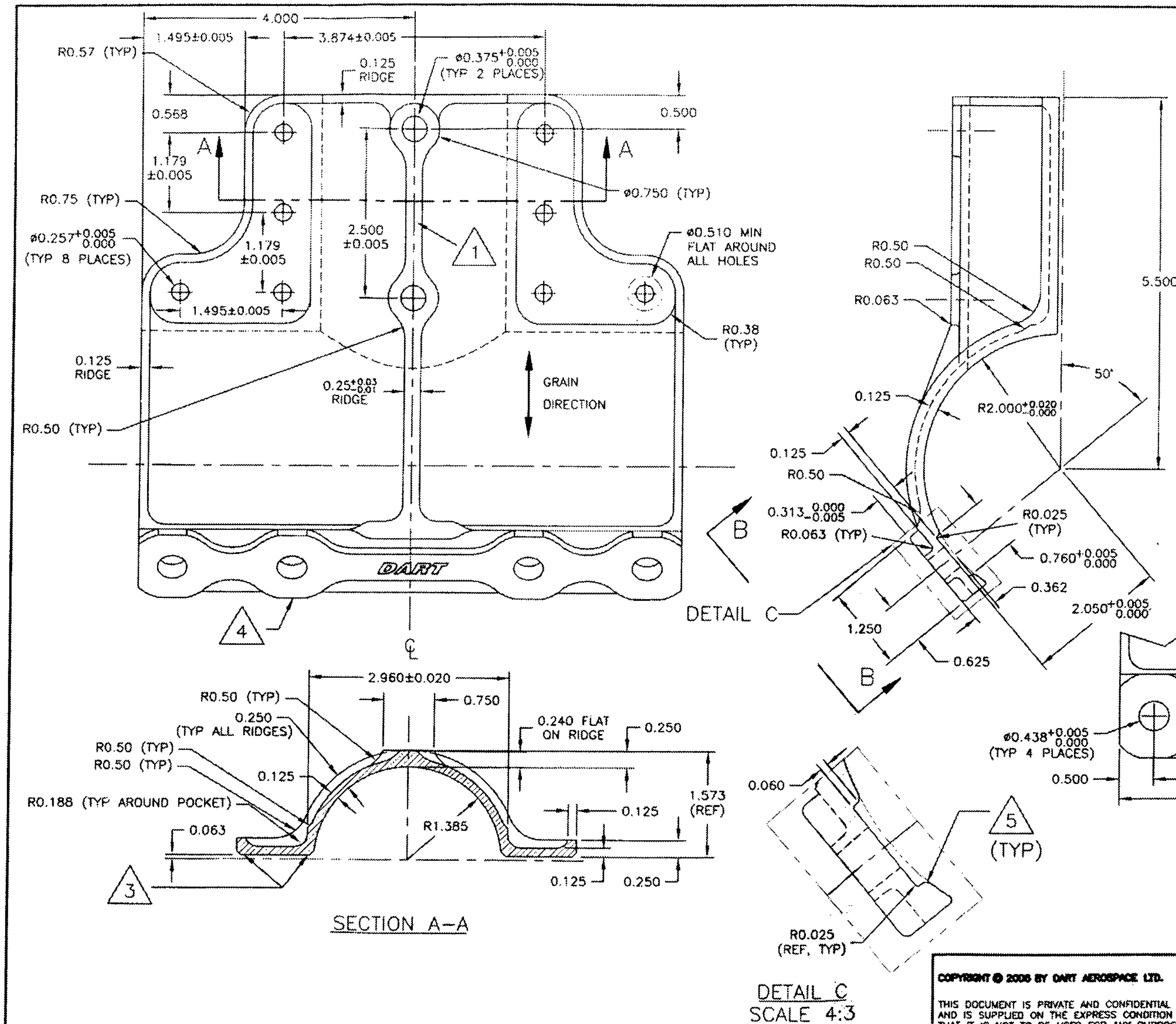
QA Closed: Date:

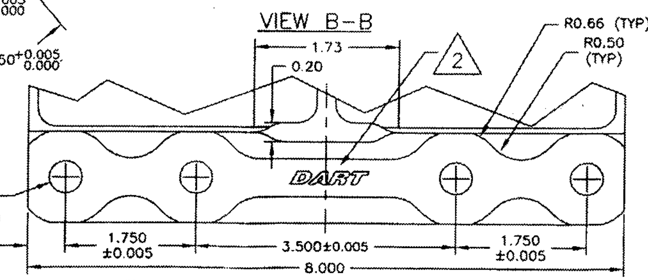
Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		





RELEASED 05.12.06

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
3. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
4. CHAMFER 0.063" x 45° ALL AROUND
5. CHAMFER 0.033" x 45° (SEE DETAIL C)

E

REV	DATE	DESCRIPTION
E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO. D2571 — REV. E — SHEET 1 OF 1
DATE 05.07.13		TITLE OUTER FWD SADDLE — SCALE 2:3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 90230 MLJ
12/09/12

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☒	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	**General**			
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